

NCR-19-7545



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

4.5NR-13

Job Sheet 189389



Part No: 4.5NR-13

Job Qty: 6 pcs

Part Name: Lock Bearing Screw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 4.5NR-13 Rev.A IPP Rev. A 18.12.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	6 pcs	2/8/19		0.00	3.00	Conventional Lathe - 1		71 9-89 19-4-16
							Conventional Lathe - 2		
110	QC 2	6 pcs	2/8/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S172787



Part: 4.5NR-13

Job No: 189389

Serial No/Batch: S172787

Revision: A

Inspector:

Exp Date:

Instructions:

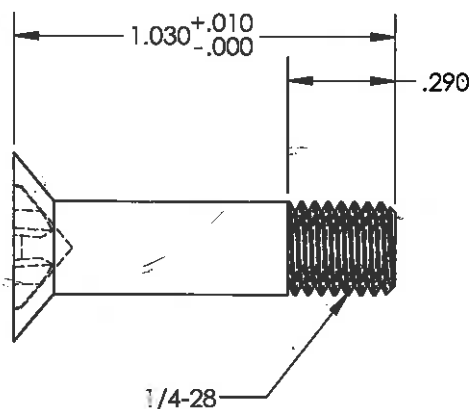
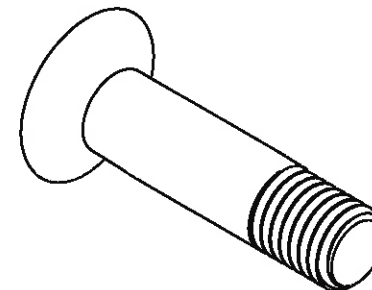
Date: 04/16/19

				QC 2 - 63			
				QC 2 - 8			
				QC 2 - 71			
120 QC 8	6 pcs	2/8/19	0.00 0.00	QC 8 - 12			
				QC 8 - 14			
				QC 8 - 17			
				QC 8 - 20			
				QC 8 - 25			
				QC 8 - 3			
				QC 8 - 32			
				QC 8 - 33			
				QC 8 - 35			
				QC 8 - 38			
				QC 8 - 39			
				QC 8 - 4			
				QC 8 - 44			
				QC 8 - 45			
				QC 8 - 49			
				QC 8 - 58			
				QC 8 - 8	Do 19-04-17		
				QC 8 - 9			
				QC 8 - 68			
121 Outsource - 13 - Zinc Plating	6 pcs	2/8/19		GRO002-VC	2019-05-02		
122 Packaging 2-1 - Receive - B4B	6 pcs	2/8/19	0.00 0.00	Packaging 2 - 1 - B4B	MAY 09 2019 PAS		
124 QC 6	6 pcs	2/8/19	0.00 0.00	QC 6 - 40	MAY 10 2019 40		
130 Packaging 3-1 - Stock - B4B	6 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B	8-89		
				Packaging 3 - 2 - B4B			
				Packaging 3 - 3 - B4B			
				Packaging 3 - 4 - B4B			
				Packaging 3 - 5 - B4B	GA2103 MAY 13 2019		
140 QC 21 - SA	6 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	21 MAY 13 2019		
Part Op 100 - 1-Machine as per DWG. 2-Deburr Descriptions: 121 - -Issue P/O; _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; Steel -Certificate of Conformity is required 130 - .							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
MS24694-S112	Lock Bearing Screw 1/4-28 X 1-5/8	6 Ea (1 ea)	100-Conventional Lathe - 1	S141229 GA014			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-Conventional Lathe - 1	MS24694-S112	6	44	0			
Part Specifications							
Specifications could not be found.							

Plex 4/18/19 2:39 PM dart.lacelle.linda

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
		ADDED DRAWING TO SHOW MODIFICATIONS TO MS24694-S112.	7/21/2014	JAG	DW
A	14-0095	ADDED BAG & LABEL NOTE.	7/28/2014	DPD	RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AME
WITHOUT NC
WORK OF
NO. 189389 MS
190123

NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK BEARING SCREW	
DWG NO. 4.5NR-13	REV A
MAT'L STEEL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± .6°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 7/18/2014 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			4.5NR-13	1	LOCK BEARING SCREW	STEEL	1/4-28 X 1-5/8 MS24694-S112 (MODIFIED)

Part #[illegible]

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

H:\FORMS\Quality Assurance\approved QA\Inspection Sheet revB



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB043357**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043357

PO Date: 5/2/19

Due Date: 5/10/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189389	4.5NR-13	Lock Bearing Screw -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; Steel -Certificate of Conformity is required	Firmed	-	5/10/19	6 pcs	0 pcs	6 pcs	\$7.50/pcs	\$45.00
				6x		MAY 09 2019					
2	192390	RB877212-08-9	Spring Guide, Ø3/4 x 5/16 -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	5/10/19	6 pcs	0 pcs	6 pcs	\$7.50/pcs	\$45.00
				6x		MAY 09 2019					
Grand Total:											\$90.00



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PURCHASE ORDER

POHB043357



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/3/19 9:29 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018932- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
03-May-2019		SVETLANA DORZHIYEVA				POHB043357			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	4.5NR-13 Rev.	4.5NR-13 LOCK BEARING SCREW 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ZINC PLATE, ASTM B633 TYPE 2 SC 2		ZINC CH	6	6	0	0	0
2	R8877212-08-9 Rev.	R8877212-08-9 SPRING GUIDE 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC 2		ZINC CH	6	6	0	0	0

RECEIVED

MAY 09 2019

DART AEROSPACE LTD.

RECEIVED
 MAY 08 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered:

Date:

JR Oct 24/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7545

Route update only ☐

Job: <u>189389</u> Part No. <u>4.5 NR-13</u> <u>REV A</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>4/22/19</u>		Sequence #:		QTY Affected: <u>6</u>		MRB (QSI042) <u>WP</u> <u>16/06/22</u>																													
Description Work Order Deviation				Disposition																															
- NEED TO ADD FINISH ZINC PLATE TYPE 2				- FIT FORM AND FUNCTION WILL BE AS ORIGINALLY INTENDED - THIS DEVIATION IS ACCEPTABLE TO USE AS IS																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																																			